



Critical Wear Areas & Vacuum Test Locations



NOTE: OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear.

Lower Valve Body – Bottom Side • U250E Shown Here

Click on Sonnax part numbers to see more information.

4-5 Shift Valve

- Delayed 3rd
- UD/C3 Clutch burned
- Delayed or no 5th gear

B2 (Low/Reverse) Switch Valve

- B2 Brake clutches burned
- Delayed Reverse
- Loss of engine braking in manual low

B2 (Low/Reverse) Apply Control Plunger

- B2 Brake clutches burned
- Delayed Reverse
- No engine braking in manual low

Replace with **Sonnax Part No. 27741-06K**

B1 (2nd) Apply Control Plunger

- B1 Brake clutches burned
- 2-3 or 4-3 Bind-up
- Harsh upshifts

Replace with **Sonnax Part No. 27741-04K**

NOTE: Seal port on opposite side when testing.

Boost Valve

- Low line rise in Drive
- Soft shifts
- High line pressure in Reverse

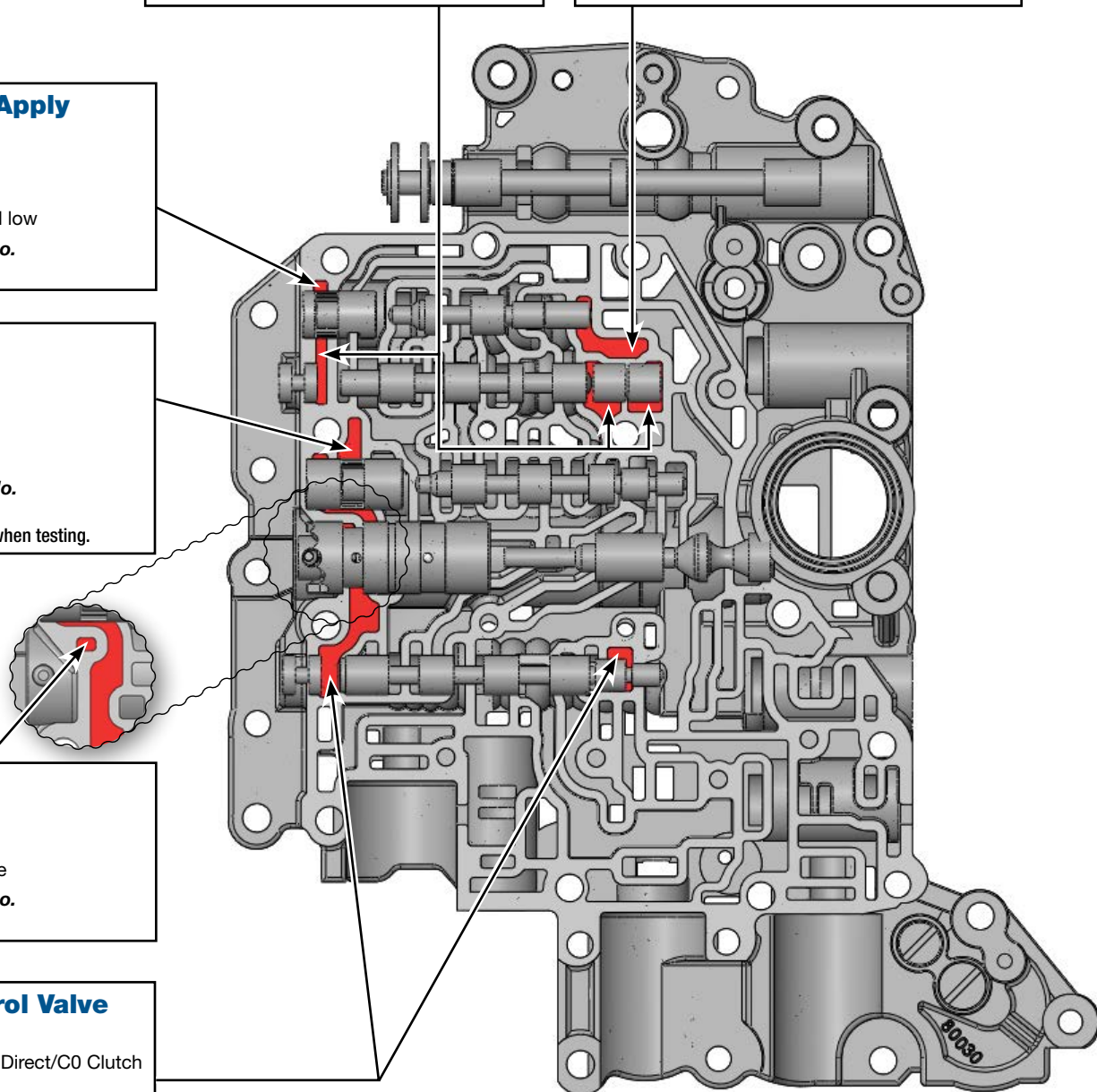
Replace with **Sonnax Part No. 27741-01K**

Clutch Apply Control Valve

- Flare shifts & bind-ups
- Burned Forward/C1 Clutch, Direct/C0 Clutch & 2nd/B1 Brake

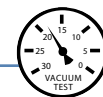
Replace with **Sonnax Part No. 27741-18K** Requires **F-27741-TL18** & **VB-FIX**

NOTE: Stroke valve to ensure it is not stuck.





Critical Wear Areas & Vacuum Test Locations



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Lower Valve Body – Bottom Side • U250E Shown Here

Click on Sonnax part numbers to see more information.

End Plugs, Multiple Locations

- Shift concerns
- Clutch failure

Replace with **Sonnax Part No. 27741-20K**

NOTE: Two Locations = ★

Pressure Regulator Valve

- Low/High line pressure
- Soft/Harsh shifts
- Clutch & brake failures
- High line pressure in Reverse
- Low converter pressure

Replace with **Sonnax Part No. 27741-08K** Requires 57917E-TL8

Clutch Apply Control Valve

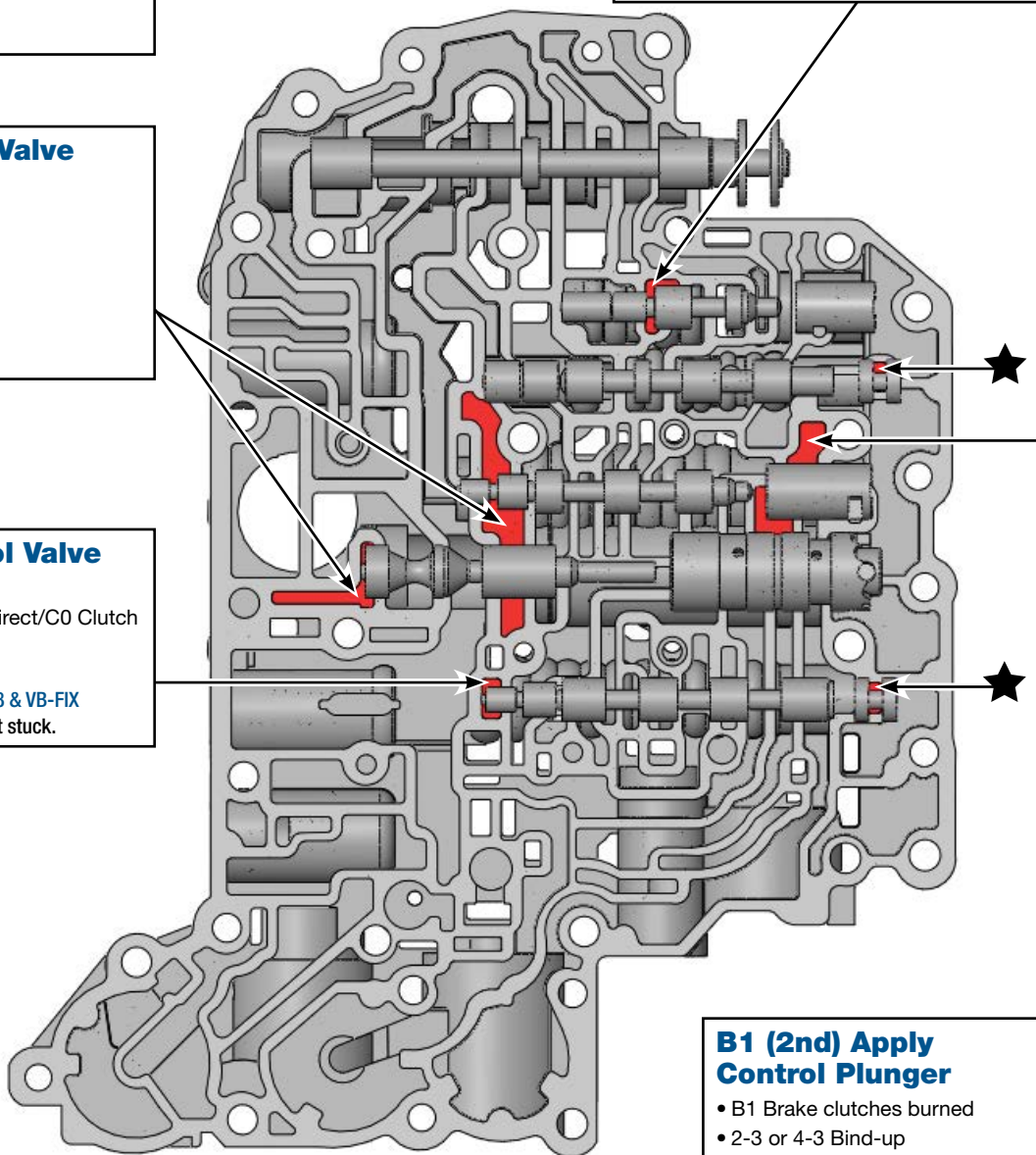
- Flare shifts and bind-ups
- Burned Forward/C1 Clutch, Direct/C0 Clutch & 2nd/B1 Brake

Replace with **Sonnax Part No. 27741-18K** Requires F-27741-TL18 & VB-FIX

NOTE: Stroke valve to ensure it is not stuck.

B2 (Low/Reverse) Switch Valve

- B2 Brake clutches burned
- Delayed Reverse
- Loss of engine braking in manual low



B1 (2nd) Apply Control Plunger

- B1 Brake clutches burned
- 2-3 or 4-3 Bind-up
- Harsh 1 through 4 maneuver shifts

Replace with **Sonnax Part No. 27741-04K**

NOTE: Seal this port and test on opposite side.



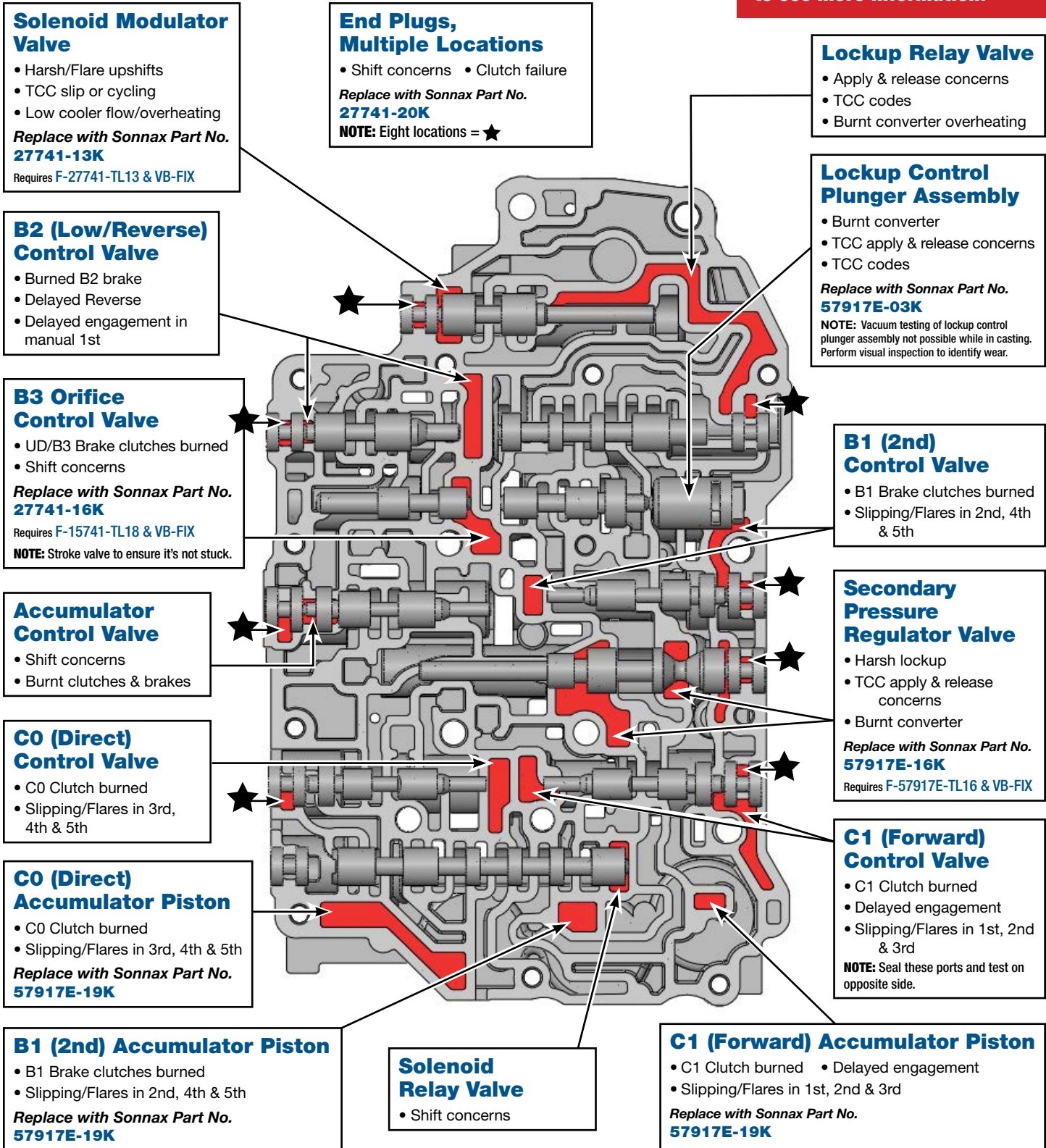
Critical Wear Areas & Vacuum Test Locations



NOTE: OE valves are shown in rest position and should be tested in rest position unless otherwise indicated. Test locations are pointed to with an arrow. Springs are not shown for visual clarity. Low vacuum reading indicates wear.

Upper Valve Body – Bottom Side • U250E Shown Here

Click on Sonnax part numbers to see more information.



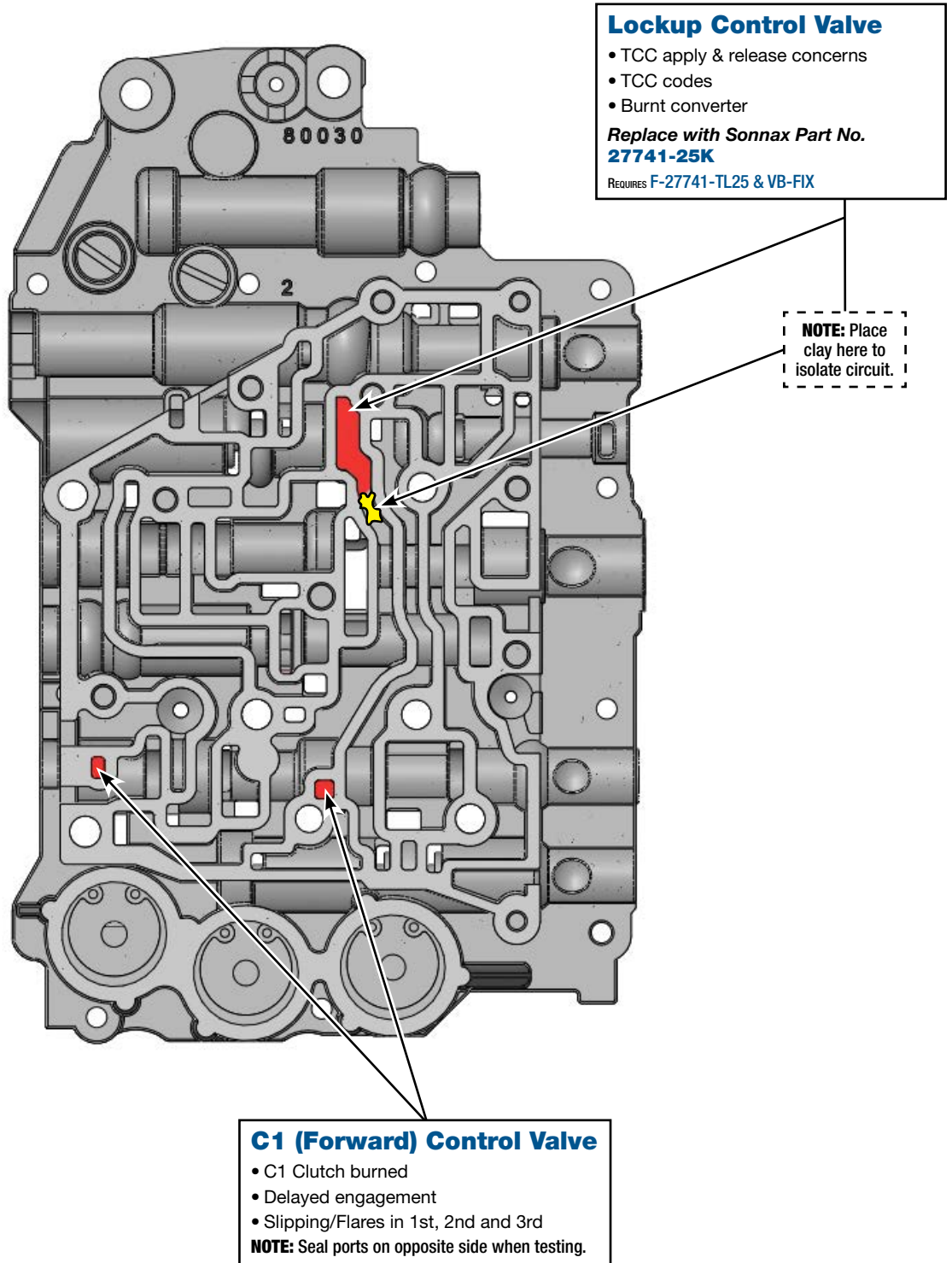


Critical Wear Areas & Vacuum Test Locations



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Upper Valve Body – Top Side • U250E Shown Here



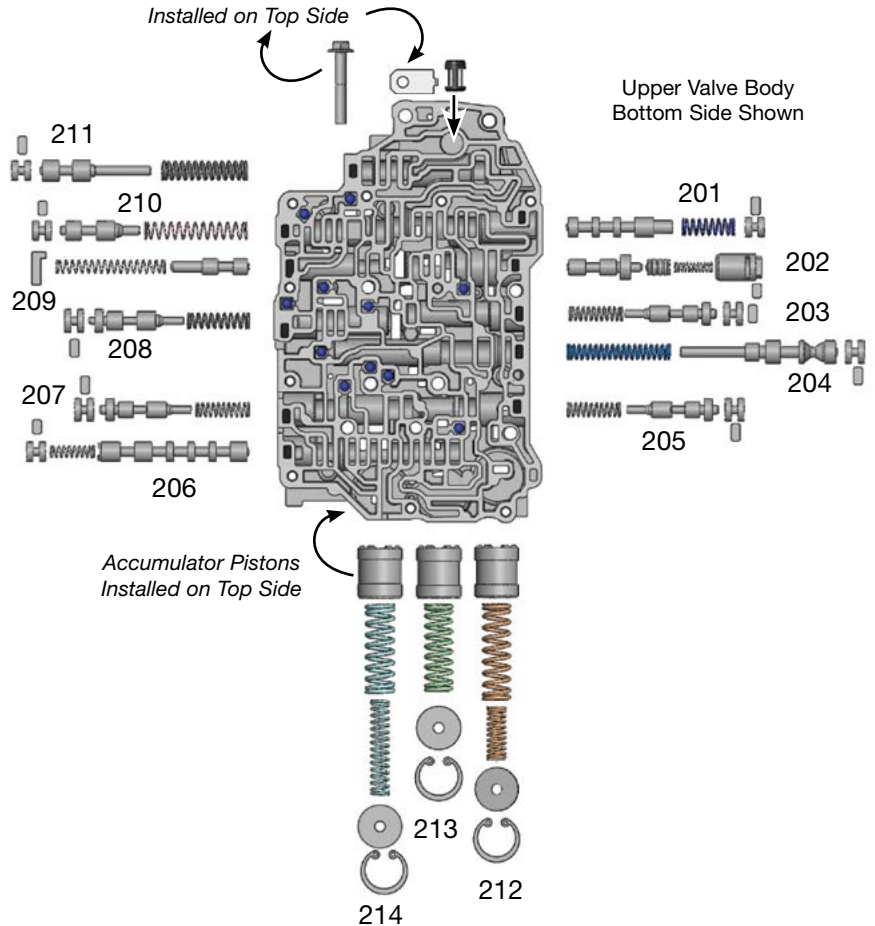


OE Exploded View

Upper & Lower Valve Body • U250E Shown Here

Upper Valve Body Descriptions

I.D. No.	Description
201	Lockup Relay Valve
202	Lockup Control Valve & Plunger Valve Assembly
203	B1 Control Valve
204	Secondary Regulator Valve
205	C1 Control Valve
206	Solenoid Relay Valve
207	C0 Control Valve
208	Accumulator Control Valve
209	B3 Orifice Control Valve
210	B2 Control Valve
211	Solenoid Modulator Valve
212	C0 Accumulator Piston
213	B1 Accumulator Piston
214	C1 Accumulator Piston



Lower Valve Body Descriptions

I.D. No.	Description
101	Manual Valve
102	B2 Switch Valve & Plunger Valve
103	4-5 Shift Valve
104	B1 Switch Valve & Plunger Valve Assembly
105	Main Pressure Regulator Valve & Boost Valve Assembly
106	Clutch Apply Control Valve

